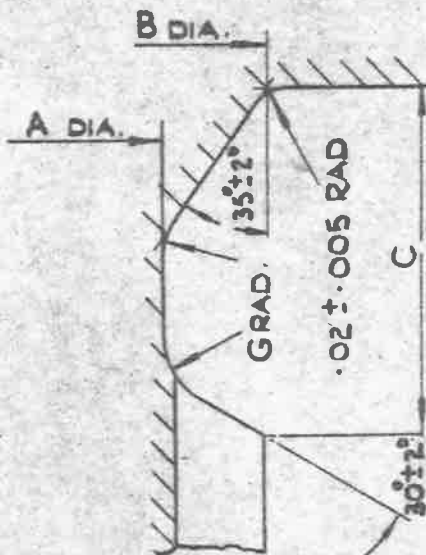


NOTE:- POSITION OF HOLES 'H' RELATIVE TO FLATS OR CORNERS OF HEXAGONS IS UNIMPORTANT.

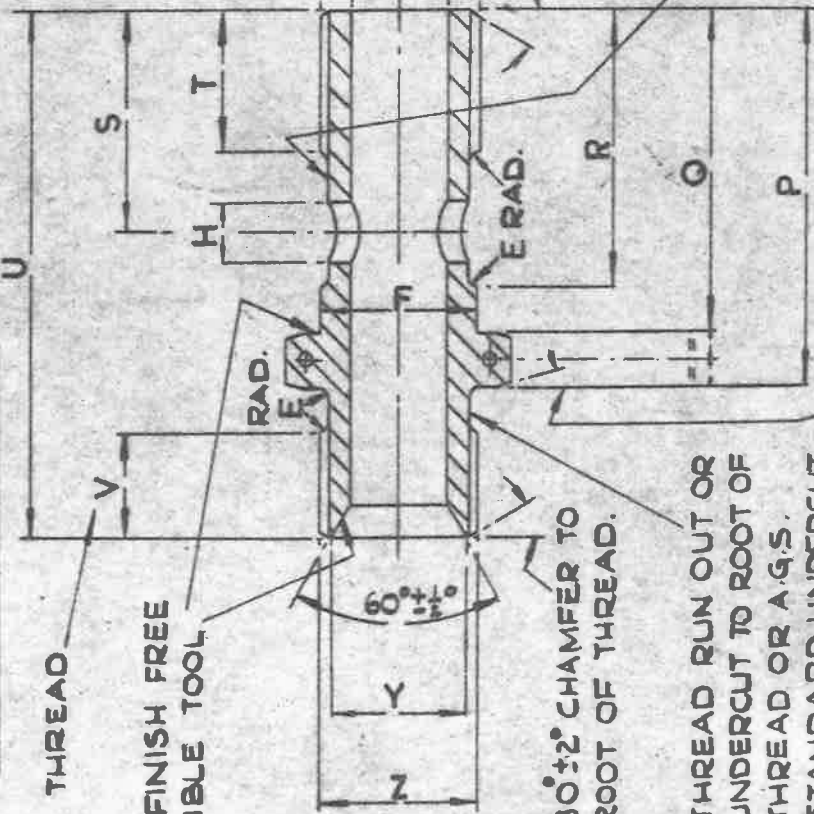
ALL DIMENSIONS ARE IN INCHES. SEE A.G.S. 100 FOR GENERAL INFORMATION.

ALL SHARP EDGES AND BURRS TO BE REMOVED.

MIN. FULL THREAD
SMOOTH FINISH FREE FROM VISIBLE TOOL MARKS.



ENLARGED VIEW OF A.G.S. STANDARD UNDERCUT.



30°±2° CHAMFER TO ROOT OF THREAD.

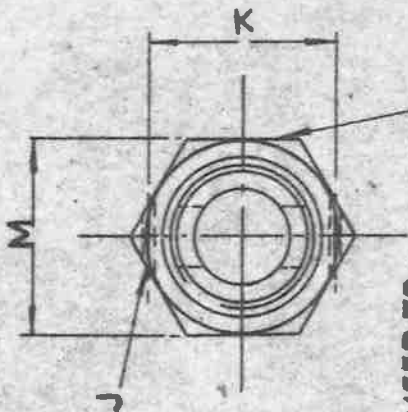
THREAD RUN OUT OR UNDERCUT TO ROOT OF THREAD OR A.G.S. STANDARD UNDERCUT.

15°±2° CHAMFER BOTH SIDES OF HEXAGON.

30°±2° CHAMFER TO ROOT OF THREAD.

UNDERCUT TO ROOT OF THREAD.

A.G.S. 1137 - * TO BE LEGIBLY & DURABLY MARKED ON THIS OR OPPOSITE FACE (* MARK).



MATERIAL:- STEEL TO B.S. SPEC: 5.94 (LATEST ISSUE).

FINISH:- CADMIUM PLATE TO SPEC: D.T.D. 904 (LATEST ISSUE).

NOTES:- SCREW THREADS TO B.S. SPEC: 84 (LATEST ISSUE) MEDIUM FIT, TRUNCATED. FOR DIAMETERS, TOLERANCES AND TRUNCATED DIMENSIONS OF MARKS BB & CC SEE A.G.S. 100 SHEET 5.

WORKING PRESSURES:- 3,000 LB./SQ.IN. FOR SIZES UP TO 1/2 B.S.P., 500 LB./SQ.IN. FOR SIZES 5/8 TO 1 B.S.P. FOR GENERAL ARRANGEMENT SEE A.G.S. 1128 SHEET 2.

TITLE PIPE COUPLINGS (FOR LIGHT ALLOY RANGE) BANJO BOLT WITH UNION HEAD CONNECTION

ISSUE	4	5	5
ALT. NO.	AS/AGS 969	AS/AGS 988	SM 856

MINISTRY OF SUPPLY
APPLICATIONS FOR A.G.S. SHEETS TO:- AT.P.4, BLOCK 'E', CHESSINGTON, SURREY.
GENERAL ENQUIRIES TO:- A.D.S.A.E. ST. GILES COURT, 1-13 ST. GILES HIGH STREET, LONDON W.C.2.

R.A.E. APPROVAL	
SIGNATURE	DATE
<i>H. C. Smith</i>	27.7.54
A.D.S.A.E. APPROVAL	
SIGNATURE	DATE
<i>G. T. Robinson</i>	6/8/54

NUMBER OF SHEETS
2

A.G.S. No. 1137 SHEET 1

ALL DIMENSIONS ARE IN INCHES.

A.G.S. 1137

SHEET 2

MARK	O/D OF PIPE	Z	Y	V	U	T	S	R	Q	P	M	L	K	J	H	G	F	E	C	B	A
A	$\frac{3}{16}$	$\frac{1}{8}$.295	.35	1.75	.53	.72	.83	1.01	1.26	.600	$\frac{5}{32}$.54	$\frac{1}{16}$	$\frac{9}{64}$.02	.375	.04	.10	.39	.330
B	$\frac{1}{4}$	$\frac{1}{4}$.410	.35	1.90	.53	.75	.93	1.11	1.36	.710	$\frac{7}{32}$.67	$\frac{1}{16}$	$\frac{3}{16}$.03	.507	.05	.14	.52	.440
BB	$\frac{5}{16}$	$\frac{19}{64}$ P.I. 60% ϕ	.480	.40	2.09	.60	.88	1.06	1.26	1.51	.820	$\frac{5}{16}$.79	$\frac{1}{16}$	$\frac{13}{64}$.03	.589	.06	.14	.60	.525
C	$\frac{3}{8}$	$\frac{3}{8}$.550	.40	2.19	.60	.95	1.16	1.36	1.61	.920	$\frac{3}{8}$.92	$\frac{1}{16}$	$\frac{15}{64}$.03	.645	.06	.14	.66	.580
CC	$\frac{7}{16}$	$\frac{14}{64}$ P.I. 75% ϕ	.600	.45	2.53	.68	1.05	1.28	1.51	1.79	1.010	$\frac{7}{16}$.96	$\frac{1}{16}$	$\frac{17}{64}$.04	.736	.06	.18	.75	.650
D	$\frac{1}{2}$	$\frac{1}{2}$.690	.53	2.71	.73	1.14	1.43	1.66	1.94	1.010	$\frac{1}{2}$.96	$\frac{1}{16}$	$\frac{5}{16}$.04	.811	.06	.18	.83	.720
E	$\frac{5}{8}$	$\frac{5}{8}$.760	.55	2.85	.73	1.20	1.53	1.76	2.06	1.100	$\frac{9}{16}$	1.06	$\frac{1}{16}$	$\frac{13}{32}$.04	.888	.06	.18	.91	.800
F	$\frac{3}{4}$	$\frac{3}{4}$.900	.55	3.05	.83	1.33	1.68	1.96	2.26	1.300	$\frac{11}{16}$	1.26	$\frac{1}{2}$ (N ^o 48)	.04	1.027	.06	.18	1.05	.940	
G	$\frac{7}{8}$	$\frac{7}{8}$	1.040	.65	3.40	.88	1.48	1.88	2.16	2.51	1.390	$\frac{13}{16}$	1.37	$\frac{19}{32}$ (N ^o 48)	.04	1.175	.06	.18	1.19	1.085	
H	1	1	1.130	.70	3.89	.97	1.72	2.22	2.54	2.89	1.670	$\frac{15}{16}$	1.68	$\frac{11}{16}$ (N ^o 48)	.05	1.291	.06	.23	1.31	1.180	

TITLE PIPE COUPLINGS (FOR LIGHT ALLOY RANGE) BANJO BOLT WITH UNION HEAD CONNECTION.

ISSUE 5/1/54

ALT. NO. AS/AGS 969

MINISTRY OF SUPPLY
 APPLICATIONS FOR A.G.S. SHEETS TO:
 AT.P4, BLOCK 'E', CHESSINGTON, SURREY.
 GENERAL ENQUIRIES TO:
 A.D./S.A.E. ST. GILES COURT, 1-13
 ST. GILES HIGH STREET, LONDON W.C.2.

R.A.E. APPROVAL
 SIGNATURE *[Signature]* DATE 27.7.54
 A.D./S.A.E. APPROVAL
 SIGNATURE *[Signature]* DATE 6/8/54

NUMBER OF SHEETS
 2

A.G.S. NO.
 1137
 SHEET 2

AGS.1137 SHEET 2

SM2027

M A R K	O/D OF PIPE	A										DRILL		DRILL		MIN										BSPE THREAD
		A	B	C	E	F	G	H	J	K	L	M	P	Q	R	S	T	U	V	Y	Z					
A	3/16	.330	.390	.110	.045	.380	.025	.09	1/16	.550	5/32	.600	1.270	.010	.840	.730	.550	1.760	.300	.1						
B	1/4	.440	.520	.150	.055	.512	.035	.3	1/16	.680	7/32	.710	1.370	.110	.940	.760	.550	1.910	.415	1/4						
B-B	5/16	.525	.600	.150	.065	.594	.035	13/16	1/16	.800	5/16	.820	1.520	.1260	1.070	.890	.620	2.100	.485	19/32						
C	3/8	.580	.660	.150	.065	.650	.035	15/16	1/16	.930	3/8	.920	1.620	1.360	1.170	.960	.620	2.200	.555	3/8						
C-C	7/16	.650	.750	.190	.065	.741	.045	17/16	1/16	.970	7/16	1.010	1.800	1.510	1.290	1.060	.700	2.540	.605	M.F.P.L. 750/0.0 WHIT. (6584)						
D	1 1/2	.720	.830	.190	.065	.816	.045	5/16	1/16	.970	1	1.010	1.950	1.660	1.440	1.150	.750	2.720	.695	1 1/2						
E	5/8	.800	.910	.190	.065	.895	.045	13/16	1/16	1.070	9/16	1.100	2.070	1.760	1.540	1.210	.750	2.860	.765	5/8						
F	3/4	.940	1.050	.190	.065	1.032	.045	1	1/16	1.270	11/16	1.300	2.270	1.960	1.690	1.340	.850	3.060	.905	3/4						
G	7/8	1.080	1.180	.190	.065	1.175	.045	11/16	1/16	1.380	13/16	1.390	2.520	2.160	1.890	1.490	.900	3.410	1.045	7/8						
H	1	1.180	1.310	.240	.065	1.296	.055	1 1/16	1/16	1.670	15/16	1.670	2.900	2.540	2.230	1.730	.990	3.900	1.035	1						

ISSUED BY THE PROPERTY OF BRITISH ALUMINUM CONSTRUCTION LTD.
 28, KING ST. 1ST ST. JAMES'S, LONDON S.W.1

DESIGNED BY: DRAWN BY: CHECKED BY: DATE: PIPE COUPLINGS (ALUMINUM ALLOY RANGE) BAND BOLT WITH UNION HEAD CONNECTION.

AGS.1137 SHEET 2